

Work Order ID 62891

October 12, 2010 1:41:36 PM



Page 1

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

J

Order CL 10/10/18

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/15

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: *1015114*
Exp Date: *11/01*

10/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62891

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Page 2

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1
10-10-18

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/10/15 sf

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

i
in box
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62891

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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043A Location: <u>16A</u>								
170		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

Signature 10/18/10

10/10/18
MF
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62891

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC IPP RevC: as per dwg revC DD 10.01.18 verified by:EC IPP rev:D as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2728-3		Manufactured	No			110	Each	0.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Dart Logo label

D350-607-241		Manufactured	No			140	Each	2.0000	1				
--------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--



Basket Clamp Assembly

Location

Loc Qty

Loc Code

FG022

2

61681

2

D2022-101		Manufactured	No			110	Each	94.0000	5	5			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Spacer

Location

Loc Qty

Loc Code

ST504

94

50746

23

52325

11

61990

60

D2221		Manufactured	No			110	Each	0.0000	1				
-------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--



350 Basket Base

D2258-200		Manufactured	No			110	Each	12.0000	1				
-----------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--



Placard 2001b

Location

Loc Qty

Loc Code

ST505

12

61760

12

11/10/15

10/10/15

10/10/15

10/10/15

10/10/15

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 62891

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D2530

 Handle Weldment

Manufactured No

110 Each

12.0000

1

1



10/10/15

Location

Loc Qty

Loc Code

ST506

12

60206

2

61224

10

1

D2535

 Spring

Manufactured No

110 Each

72.0000

2

2



10/10/15

Location

Loc Qty

Loc Code

ST504

72

58331

72

2

2

D2537

 Bushing

Manufactured No

110 Each

54.0000

2

2



10/10/15

Location

Loc Qty

Loc Code

ST504

54

59122

12

59423

12

62393

30

2

2

D2931

 Bumper

Manufactured No

110 Each

784.0000

2

2



10/10/15

Location

Loc Qty

Loc Code

ST504

784

46064

784

2

1

D2989-041

 Basket Lid Assembly

Manufactured No

110 Each

0.0000

1

1



B61908 (P)

10/10/18

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 62891

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D2989-043 Manufactured No



Basket Lid Assembly

D350-607-143 Manufactured No



Automatic Lid Opener Installation

AN3-16A Purchased No



Bolt

AN4-13A Purchased No



Bolt

AN4-22A Purchased No



Bolt

Location Loc Qty Loc Code

FG032 1
54041 1

110 Each 0.0000

110 Each 1.0000

110 Each 98.0000

Location Loc Qty Loc Code

ST352 98
114752 98

110 Each 414.0000

Location Loc Qty Loc Code

ST358 414
115159 414

110 Each 201.0000

Location Loc Qty Loc Code

ST359 201
111965 2
114523 99
114784 100

B61909 (H)

1 1
10/10/18

1 1
10/10/18
B63008 (K)

2 2
10/10/18

2 2
10/10/18

5 5
10/10/18

5

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62891

Parent Item: D350-607-043A





Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

AN5-17A	Purchased	No	110	Each	86.0000	4	4																
																							
Bolt																							
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST339</td><td>86</td><td></td></tr><tr><td>114784</td><td>46</td><td></td></tr><tr><td>115594</td><td>40</td><td></td></tr></table>									Location	Loc Qty	Loc Code	ST339	86		114784	46		115594	40				
Location	Loc Qty	Loc Code																					
ST339	86																						
114784	46																						
115594	40																						
MS20600-AD4W3	Purchased	No	110	Each	1,505.000	2	2																
																							
Cherry Rivets																							
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST321</td><td>1505</td><td></td></tr><tr><td>107939</td><td>758</td><td></td></tr><tr><td>111636</td><td>747</td><td></td></tr></table>									Location	Loc Qty	Loc Code	ST321	1505		107939	758		111636	747				
Location	Loc Qty	Loc Code																					
ST321	1505																						
107939	758																						
111636	747																						
AN960JD416	NAS1149D0463J Purchased	No	110	Each	24.0000	14	14																
																							
Washer																							
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST300</td><td>24</td><td></td></tr><tr><td>113288</td><td>24</td><td></td></tr></table>									Location	Loc Qty	Loc Code	ST300	24		113288	24							
Location	Loc Qty	Loc Code																					
ST300	24																						
113288	24																						
AN960JD516	NAS1149D0563J Purchased	No	110	Each	34.0000	4	4																
																							
Washer																							
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST</td><td>34</td><td></td></tr><tr><td>103694</td><td>18</td><td></td></tr><tr><td>107534</td><td>12</td><td></td></tr><tr><td>109287</td><td>4</td><td></td></tr></table>									Location	Loc Qty	Loc Code	ST	34		103694	18		107534	12		109287	4	
Location	Loc Qty	Loc Code																					
ST	34																						
103694	18																						
107534	12																						
109287	4																						

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 62891



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

110 Each 10.0000 2 2



Washer



M115832 10/10/15

Location

Loc Qty

Loc Code

ST347

10

105059

10

NAS1515H4 Purchased No

110 Each 97.0000 2 2



Washer



10/10/15

Location

Loc Qty

Loc Code

ST277

97

111294

5

111525

92

MS21042L3 Purchased No

110 Each 2,546.000 2 2



Nut



10/10/15

Location

Loc Qty

Loc Code

ST300

2546

114523

49

114784

1497

115835

1000

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62891



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/13/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,050.000

7

7



10/10/15

Nut

Location

Loc Qty

Loc Code

ST300

4050

113422

68

114523

8

114718

16

114784

32

115108

926

115589

1900

115621

1100

7

MS21042L5

Purchased

No

110

Each

895.0000

4

4



10/10/15

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

869

115156

369

115594

500

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T. *w/10 62891*
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.

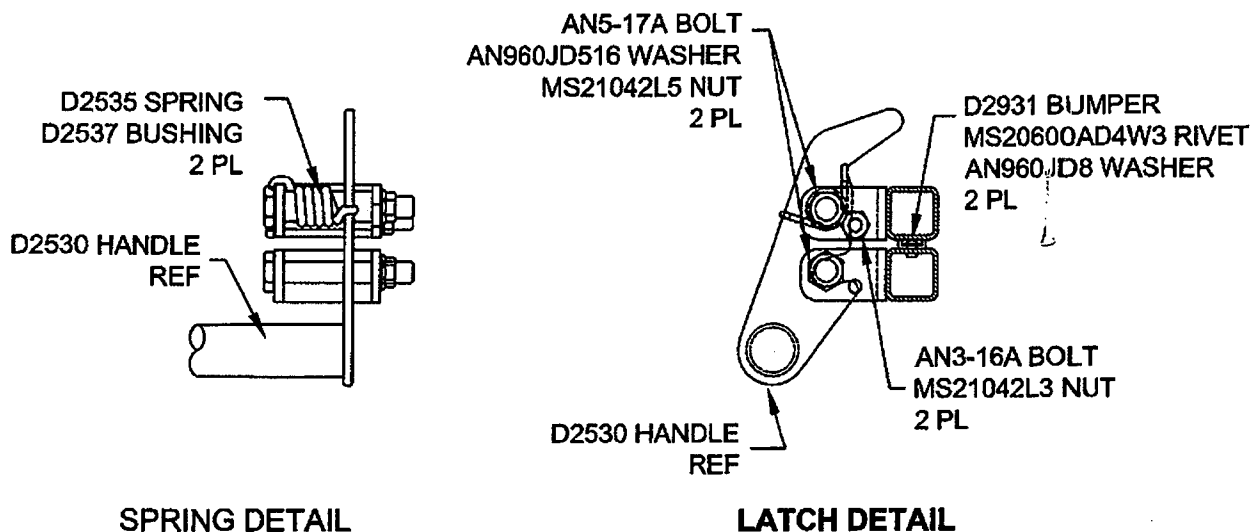
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

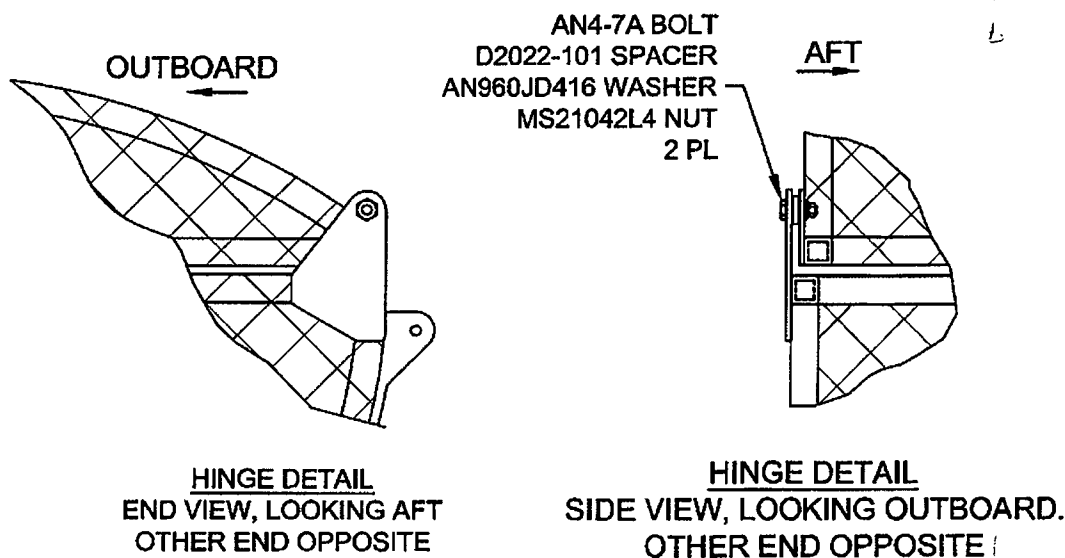
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



**DETAIL J:
HANDLE WELDMENT**



**DETAIL H:
HINGE**

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

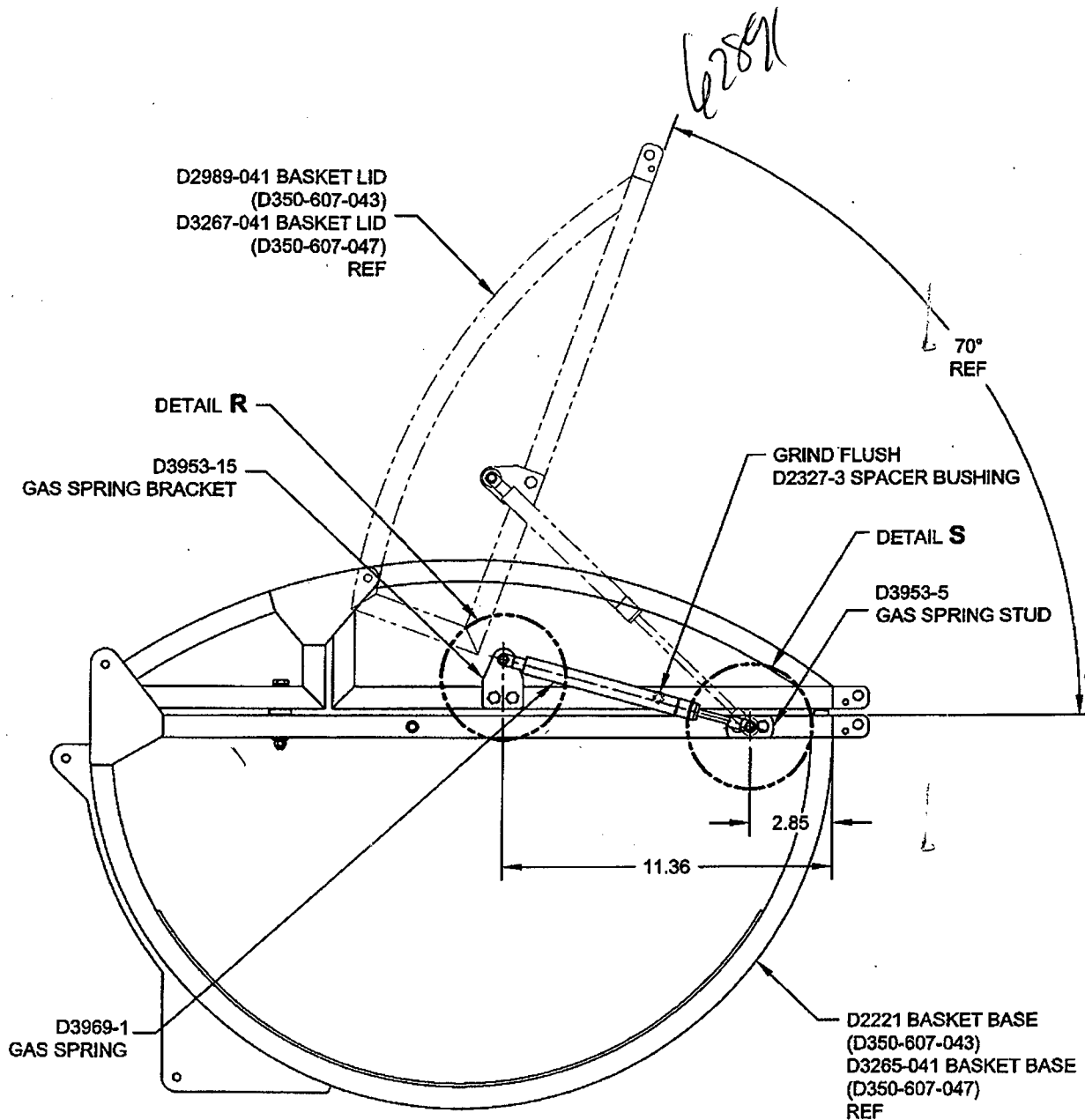
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-143 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries